

Date: Monday, 22/09/2008 2:09:06 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CABIN DOOR ROLLER KIT, LH		
Job Number	: 42195		Part Number	: D412698011		
Estimate Number	: 10276		Drawing Number	: IIN D412-698 REV E <i>JL</i>		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/09/2008 S.O. No. :		Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 20/10/2008 Qty: 22 Um: Each		
Previous Run	: 40223					
Written By	:					
Checked & Approved By	: <u>JUL08922</u>					
Comment	: Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS					
	Est Rev:D 08-01-28 change to rev D ECN 1104 DD					

Additional Product

Job Number:



Seq #:	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	<i>HJ for JLD 08.10.08</i>
	Comment: DOCUMENT CONTROL	Photocopy bluefile and create labels per PPP D412-698-011 CHG003	<i>S.08.10.08</i>
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1	Pick Packing Kit	
3.0	D3121141	Bracket Assembly	
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 66.0000 Each(s)	Pick: Packing Kit	<i>63</i>
		Qty Part Number Description Batch	<i>(3) 40250</i>
	Qty Part Number Description Batch		<i>42189 50</i>
4.0	D3121143	Bracket Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)	Pick: Packing Kit	<i>15</i>
		Qty Part Number Description Batch	<i>(7) B42190 B43486 50</i>
5.0	D3137043	Bracket Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)	Pick: Packing Kit	<i>20x</i>
		Qty Part Number Description Batch	<i>(8) 811214 50</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CABIN DOOR ROLLER KIT, LH

Job Number: 42195

Part Number: D412698011

Job Number:



Seq. #: Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0 D3183043

Bracket Assembly

16X
42193



810/10 50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3183-043 Bracket Assembly

10 *
39924

50

7.0 D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total : 198.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

9 D3199-1 Bracket

342223 173X / 8104 50

8.0 D32021

Cover



22

Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3202-1 Cover

8104

50

9.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Reo B



20x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-011

Location:

8104

50

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS
 (FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
3						D3238-1	SHIM
1						D3238-3	SHIM
2						D3238-5	SHIM
6						D3238-11	SHIM
2						D3238-13	SHIM
4						D3238-15	SHIM
						D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
	1	1	1			D3202-3	COVER
	3	3				D3674-041	BRACKET ASSEMBLY
	9	9	9			D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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Revision: E
 Date: 08.05.01